

Date: Wednesday, 01/04/2009 9:20:27 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 46764

Estimate Number : 10334

P.O. Number :

This Issue : 01/04/2009

S.O. No. :

Prsht Rev. : NC

First Issue : / /

Previous Run : 46640

Type : SMALL /MED FAB

Drawing Name : BRACKET ASSEMBLY

Part Number : D2804042

Drawing Number : D2804 REV C

Project Number : N/A

Drawing Revision : C

Material :

Due Date : 08/04/2009

Qty: 4 Um: Each

Written By :

Checked & Approved By :

Comment :

Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM
 Est Rev:G As per Rev C 06-11-08 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

D28042

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 STA 155 Bracket

Pick:

Qty Part Number

Description

Batch

1 D2804-2

Bracket

B44476 (2)

B46315 (30)

E 09/04/01

2.0

D28052

Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Stop

Pick:

Qty Part Number

Description

Batch

1 D2805-2

Stop

B46314

E 09/04/01

3.0

D2809

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Bushing

Pick:

Qty

Part Number

Description

Batch

1 D2809

Bushing

B416438 (30)

B40929 (14)

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Press D2805-2 into arm as per Dwg D2804
 2-Press Fit D2809 as per Dwg D2804

E 09/04/01 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BRACKET ASSEMBLY

Job Number: 46764

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S orlobo (44)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1110939

START TIME:

13:30

OVEN TEMPERATURE:

320°

FINISH TIME:

14:00

BR

09-04-01

(4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-01 (4)

8.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C16A

Bolt

11109147

9.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

2

MS21043-3 Nut

1110562

10.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

4 NAS1515H3

Washer

A/R

LPS-3

Corrosion Spray

1109929

09-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: BRACKET ASSEMBLY

Job Number: 46764

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 150

9/4/2

(4K)

SD

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/03

Job Completion



mf
09-04-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

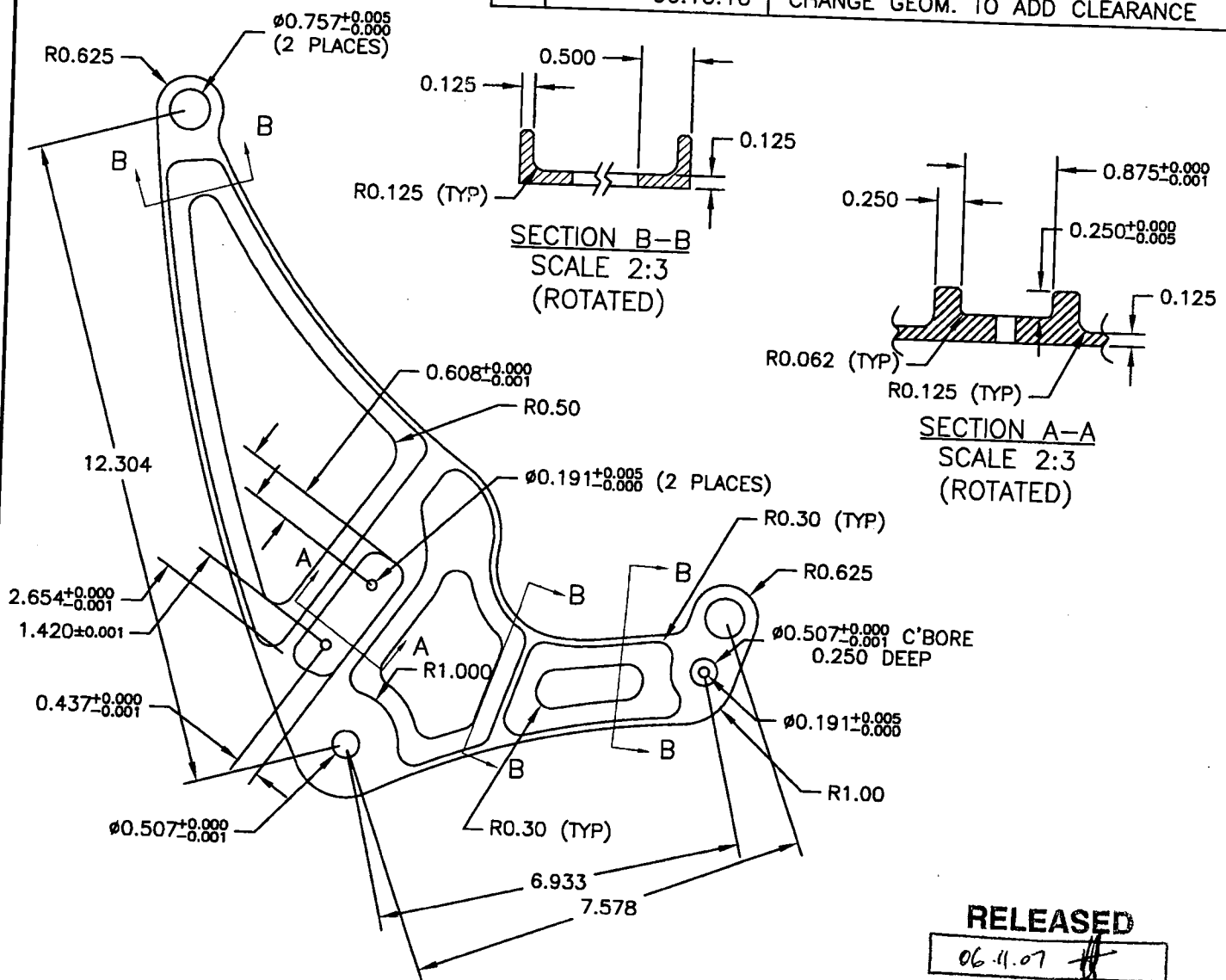
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. C
				D2804	SHEET 1 OF 2
DATE	06.10.16			TITLE	SCALE
				STA 155 BRACKET	1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	
C	06.10.16			CHANGE GEOM. TO ADD CLEARANCE	

**RELEASED**

06.11.07 #

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRJT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

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ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 416104

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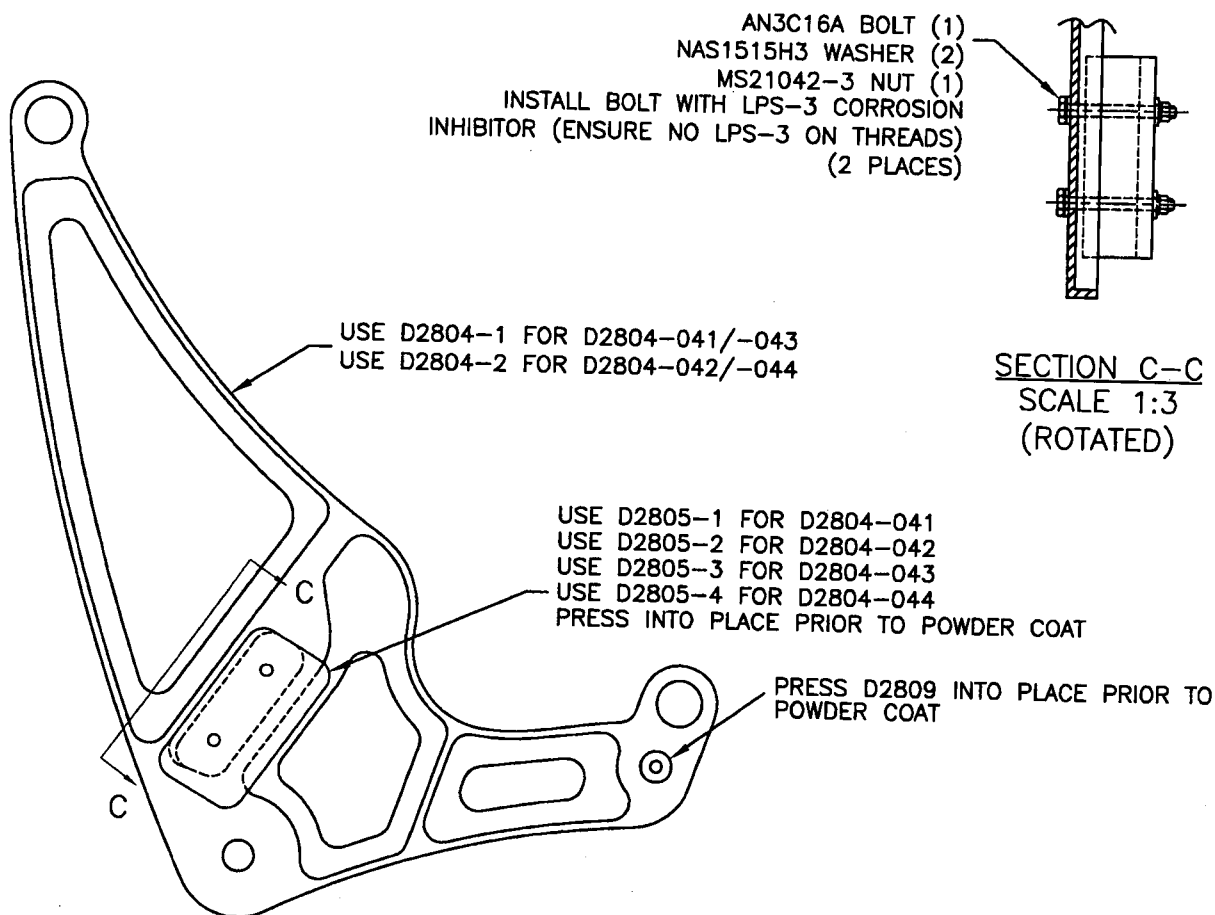
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NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2804	SHEET 2 OF 2
DATE 06.10.16	TITLE STA 155 BRACKET	SCALE 1:3	



SECTION C-C
SCALE 1:3
(ROTATED)

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WORK ORDER
NO. 410764

RELEASED

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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